

# Work Order ID 83862

**\*83862\***

Page 1

April-26-12 2:27:55 PM

Item ID: D3391-021

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Fwd Tube Assembly

Stop

**\*NS2\***

Start Date: 26/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: *MLJ*

Date: *12/04/26*

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3391

I

100

0.00

**\*100\***

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

Cut extrusion to 46.52 +0.010 -0.020

*DL 12/05/22*

110

0.00

**\*110\***

BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend as per Dwg D3391 Using Bend Prog 3391021

*DL 12/05/31*

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*6.9375*

*DD 12-6-1*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Fwd Tube Assembly

Start Date: 26/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	HAAS CNC VERTICAL MACHINING #1								
HAAS I	<b>Memo</b>	0.00							
HAAS CNC vertical machine #1	1-Machine as per Folio FA590 Rev. <u>1</u> & Dwg D3391 Rev. <u>1</u> Identify as D3391-1 2-Deburr								
140		0.00							
<b>*140*</b>	QC2- Inspect parts off machine FAI/FAIB								
QC	<b>Memo</b>	0.00							
Quality Control									
150		0.00							
<b>*150*</b>	CONVENTIONAL MILLING MACHINE								
Mill Conv.	<b>Memo</b>	0.00							
Conventional Milling Machine	Drill X1 Aft cap as per Dwg D3391 .1875" dia								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Setup Start \*NS1\*

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Item Name: Fwd Tube Assembly

Stop \*NS2\*

Start Date: 26/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC2- Inspect parts off machine FAI/FAIB

0.00

and 12/06/05

\*160\*

QC

Memo

0.00

Quality Control

170

QC8- Inspect parts - second check

0.00

SD 12516

\*170\*

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 10/05/2012 Req'd Qty: 1.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

0.00

**\*180\***

Skidtubes

0.00

Skidtubes

Memo

1-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

2-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)  
(ONLY DRILL HOLES MARKED "A")

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5- open float bag holes 0.328" and counter sink as per dwg D3391

6-Deburr & Scribe Batch number Inside aft end.

7-Transfer drill D3391-021 with D3391-023

\*\*\*NO WEARPLATE HOLES ARE TRANSFER DRILLED\*\*\*

De 12/06/20

De 12/06/21

190

QC5- Inspect part completeness to step on W/O

0.00

**\*190\***

QC

Memo

0.00

Quality Control

12/06/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

Stop **\*NS2\***

Item Name: Fwd Tube Assembly

Start Date: 26/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200

Chemical Conversion Coat per QSI005 4.1

0.00

**\*200\***

HandFinish

Memo

0.00

Hand Finishing

1 MG 126.22

210

QC7-Inspect Chemical Conversion Coat

0.00

**\*210\***

QC

Memo

0.00

Quality Control

DP 12-6-22

220

Skidtubes

0.00

**\*220\***

Skidtubes

Memo

0.00

Skidtubes

1-instal spacers as per dwg D3391  
A/R Magnabond 6398 batch: 120666  
exp. date: 13-1-30  
cure time 12hrs. as per QSI015  
2- grind crossbolt flush  
3-back drill crossbolt if necessary

DP 12-6-22  
SAD 12-06-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Fwd Tube Assembly

Start Date: 26/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

230

QC5- Inspect part completeness to step on W/O

0.00

\*230\*

QC

Memo

0.00

Quality Control

235

Pressure Wash per QSI005 4.3

0.00

\*235\*

HandFinish

Memo

0.00

Hand Finishing

AND REALODINE AS PER PAR09-043

240

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

\*240\*

Powdercoat

Memo

0.00

Powder Coating

START TIME: 1115  
OVEN TEMPERATURE: 820  
FINISH TIME: 145

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Fwd Tube Assembly

Start Date: 26/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

250

QC3- Inspect Part Finish

0.00

\*250\*

QC

Memo

0.00

Quality Control

1x 4 12/07/03

255

Skidtubes

0.00

\*255\*

Skidtubes

Memo

0.00

Skidtubes

\*\*\*\* install D3591-1 spacer as per DS19364 and wearplate as per DWG \*\*\*\*

1x 6 12/07/03

257

QC5- Inspect part completeness to step on W/O

0.00

\*257\*

QC

Memo

0.00

Quality Control

8/2/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*83862\***

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Item ID: D3391-021

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Fwd Tube Assembly

Start Date: 26/04/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

260

Identify as per dwg & Stock Location: wlg

0.00 0.00 12-742-043/1385252

**\*260\***

Packaging

Memo

0.00

Packaging

1 x  $\phi$  ML 12/07/03

280

QC21- Final Inspection - Work Order Release

0.00

**\*280\***

QC

Memo

0.00

Quality Control

CK 12/7/0

mk  
12-07-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

April-26-12 2:27:58 PM

Page 1

Work Order ID: 83862

\*83862\*

Parent Item: D3391-021

\*D3391-021\*

Parent Item Name: Fwd Tube Assembly

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP A05.09.13New issue KJ/JLM  
 IPP B06.02.10Dwg rev.D ecn 773 EC  
 IPP C06.05.02Added inspections EC  
 IPP D 07.03.13 rev F dwg EC  
 IPP E 07.11.07 revG dwg ecn1053P EC verified by: DD  
 IPP Rev:f ECN 1056 07-11-12 DD verified by: EC  
 IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC  
 IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC  
 IPP Rev I 09.02.02 added hardware EC verified by: DD IPP Rev:J  
 11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4095-051		Manufactured	No			255	Each	29 0000	1	1			

\*D4095-051\*

Wearpad Assembly

\*\*

11/07/03

Location	Loc Qty	Loc Code
FP002	29	
78914	7	
81613	22	

D6013-047

Manufactured No

100 Each 102.0000

1

\*D6013-047\*

Skidtube Material

\*\*

12/05/22

Location	Loc Qty	Loc Code
LG	102	
72505	102	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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\*D3391-021\*

Parent Item Name: Fwd Tube Assembly

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

220

Each

55.0000

4

4

\*D3670-4-200\*

SPACER

\*\*

D12-6-22

Location

Loc Qty

Loc Code

LG

84504

40

80360

40

LG001

15

72851

3

78606

12

(4)

D3401-041

Manufactured No

255

Each

17.0000

1

1

\*D3401-041\*

Tow Cap Assembly

\*\*

12/07/03

Location

Loc Qty

Loc Code

FP002

17

78990

2

82302

15

X1

AN960C10L

NAS1149C0332

Purchased

No

255

Each

0.0000

10

10

\*AN960C10I \*

washer

122063

\*\*

(x10) 12/07/03

AN3C4A

Purchased

No

255

Each

1,915.000

10

10

\*AN3C4A\*

BOLT

\*\*

12/07/03

Location

Loc Qty

Loc Code

ST350

1915

120187

849

120521

28

120769

38

121205

1000

X10

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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\*D3391-021\*

Parent Item Name: Fwd Tube Assembly

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

255

Each

842.0000

4

4

\*D3672-1\*

Phenolic Washer

\*\*

U 12/07/03

## Location

## Loc Qty

## Loc Code

ST060

842

72229

4

76277

338

80369

500

X4

AELS-1032-225

Purchased

No

255

Each

0.0000

10

10

\*AFI S-1032-225\*Y

INSERT

\*\*

(x10) U 12/07/03

AELS-1032-225 / M118520

W/O:		WORK ORDER CHANGES					
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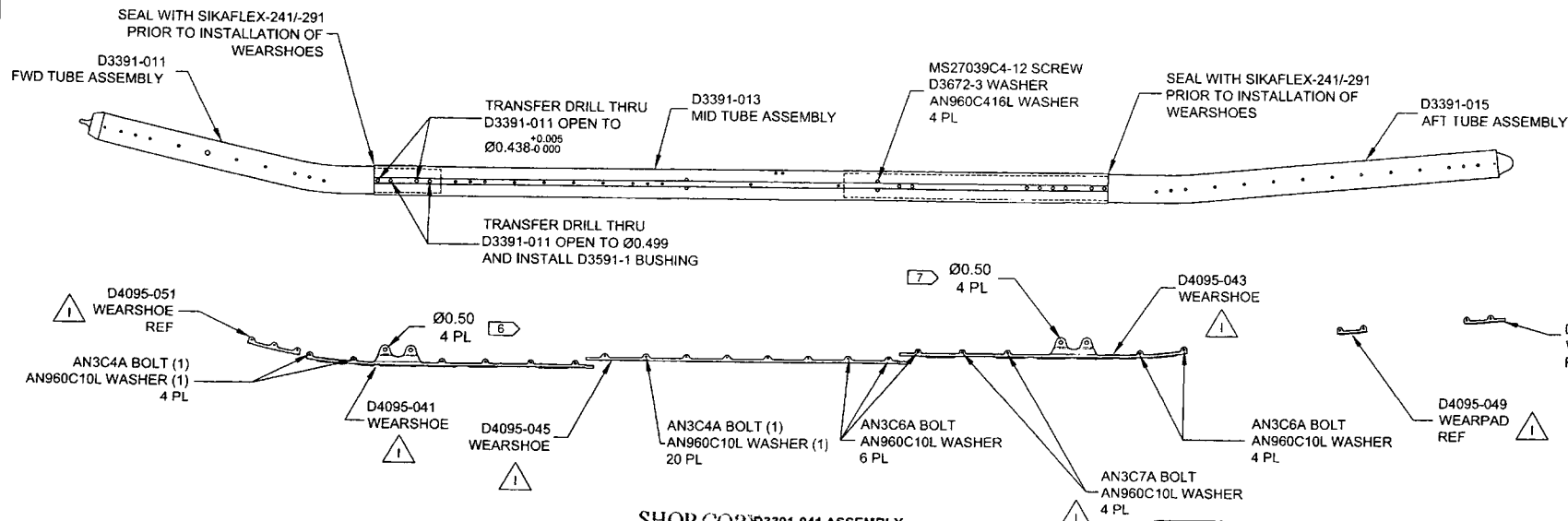
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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SHOP COPY D3391-041 ASSEMBLY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 83862 MCV  
12/04/26

RELEASED  
 2011-11-04  
 ECN# 11-662

**D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY -041	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

**GENERAL NOTES**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"  
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES  
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT  
WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH  
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND  
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH  
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND  
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

I	REMOVE GASKETS AND REPLACE ALL WEARSHOES: PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8, LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8, REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING, ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING, ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
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MFG. APPR.		D3391	SHEET 1 OF 8
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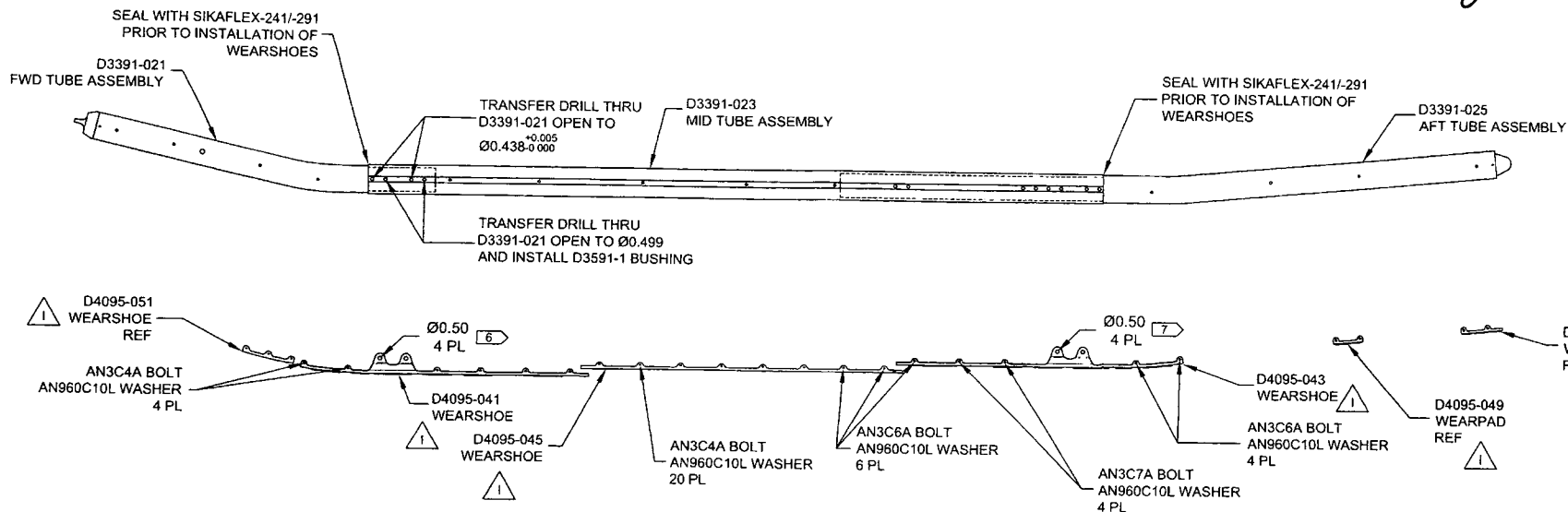
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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# **D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

## **GENERAL NOTES**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
- 3) AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 7) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL 0.50 HOLES FROM SADDLE TO D4095-041
- 8) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL 0.50 HOLES FROM SADDLE TO D4095-043

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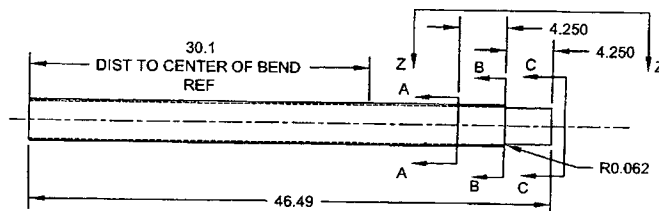
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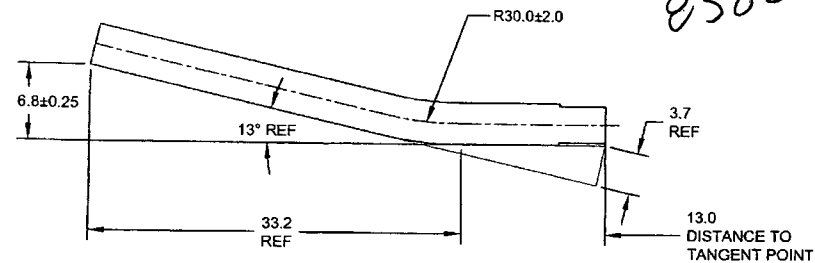
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

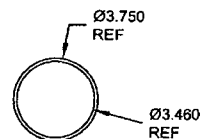
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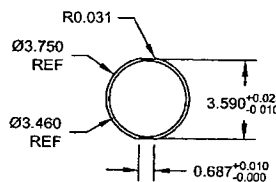
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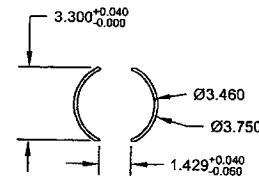
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



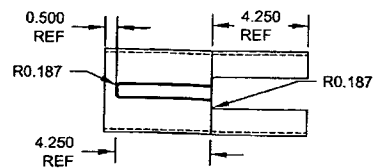
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**SECTION B-B**  
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**SECTION C-C**  
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**VIEW Z-Z**  
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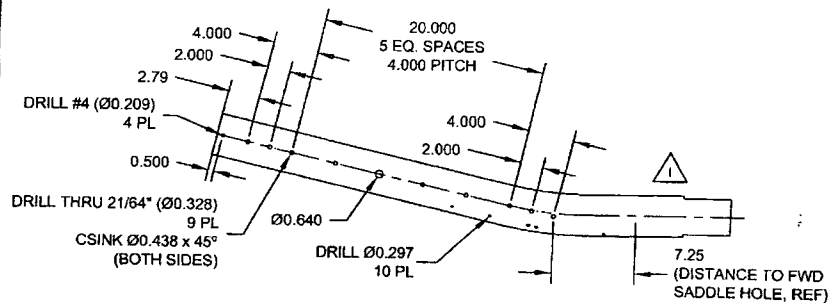
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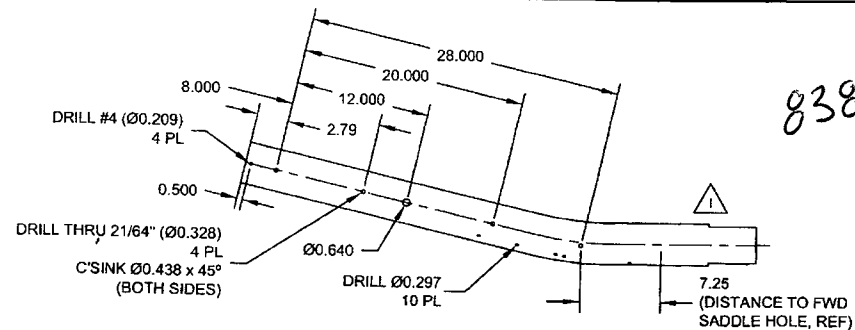
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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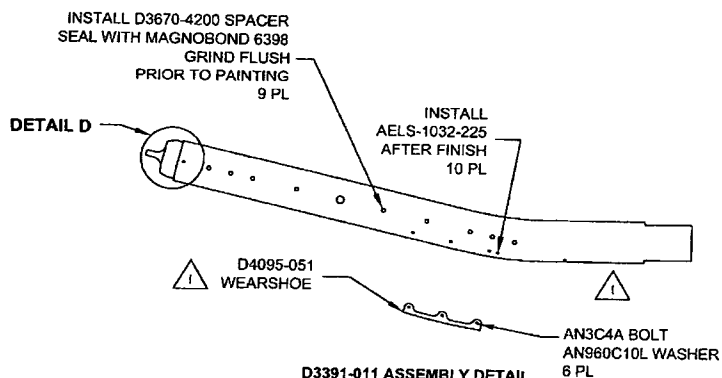
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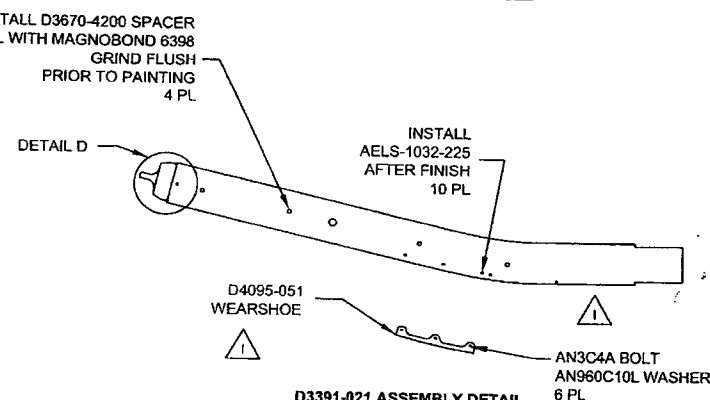
**D3391-011 DRILLING DETAIL**



**D3391-021 DRILLING DETAIL**



**D3391-011 ASSEMBLY DETAIL**

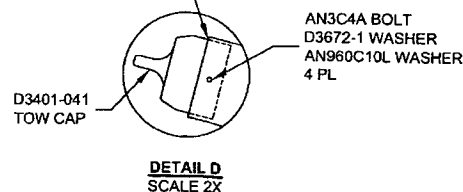


**D3391-021 ASSEMBLY DETAIL**

**D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST**

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D3401-041	TOW CAP
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
1	1	D4095-051	WEARSHOE
1	1	D6013-047	FWD TUBE
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
10	10	AELS-1032-225	INSERT

SEAL WITH  
SIKAFLEX-2411-291



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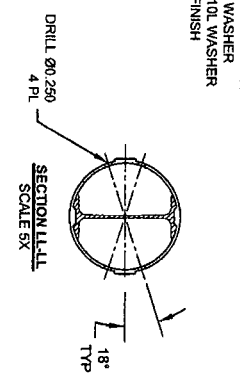
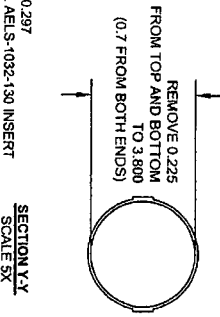
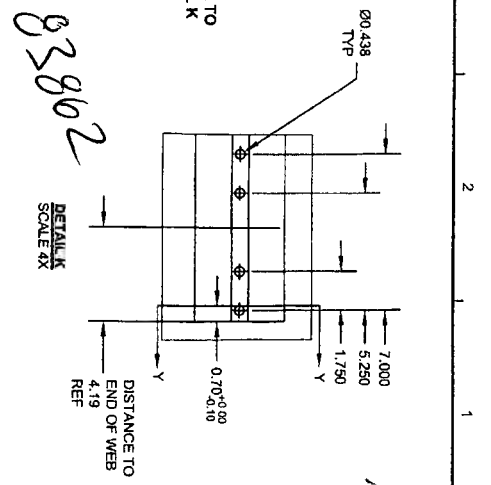
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**D3389-013 MID TUBE ASSEMBLY**  
1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION  
2) INSTALL D3389-1 WEB TO CUTTER TUBE USING SIKAFLEX-241/291 PER OSI 015  
3) WELDING: PER DART OSI 004

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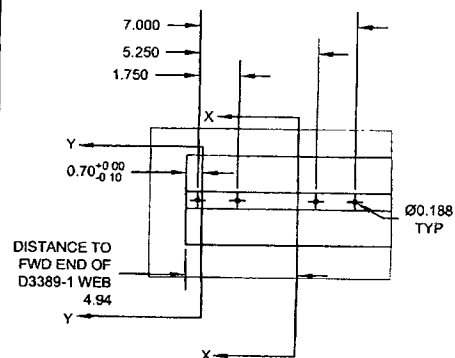
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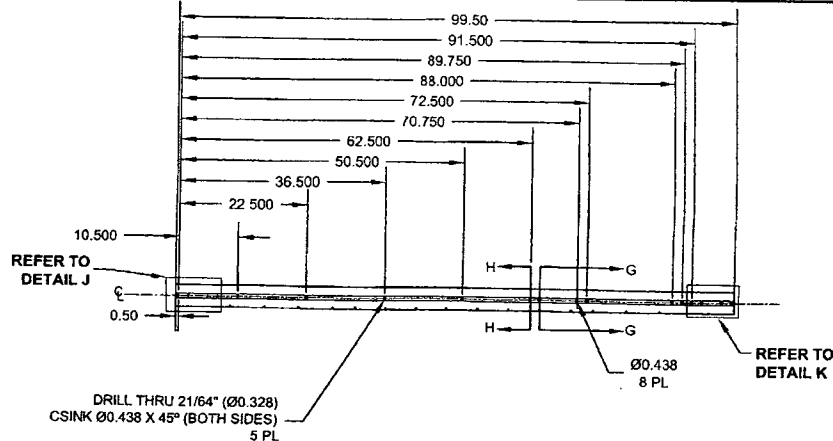
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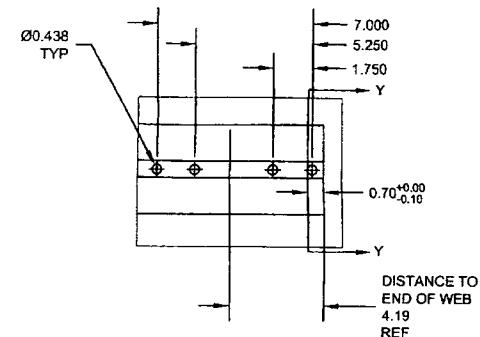
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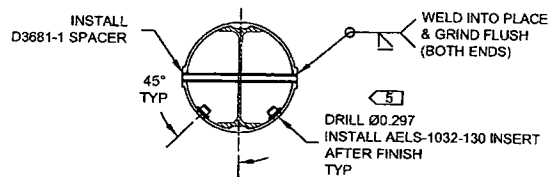
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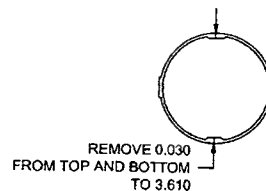
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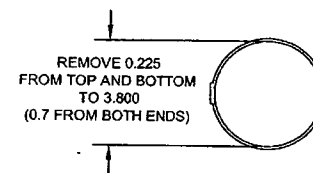
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SECTION H-H  
SCALE 5X



SECTION X-X  
SCALE 5X



SECTION Y-Y  
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- WELDING: PER DART QSI 004

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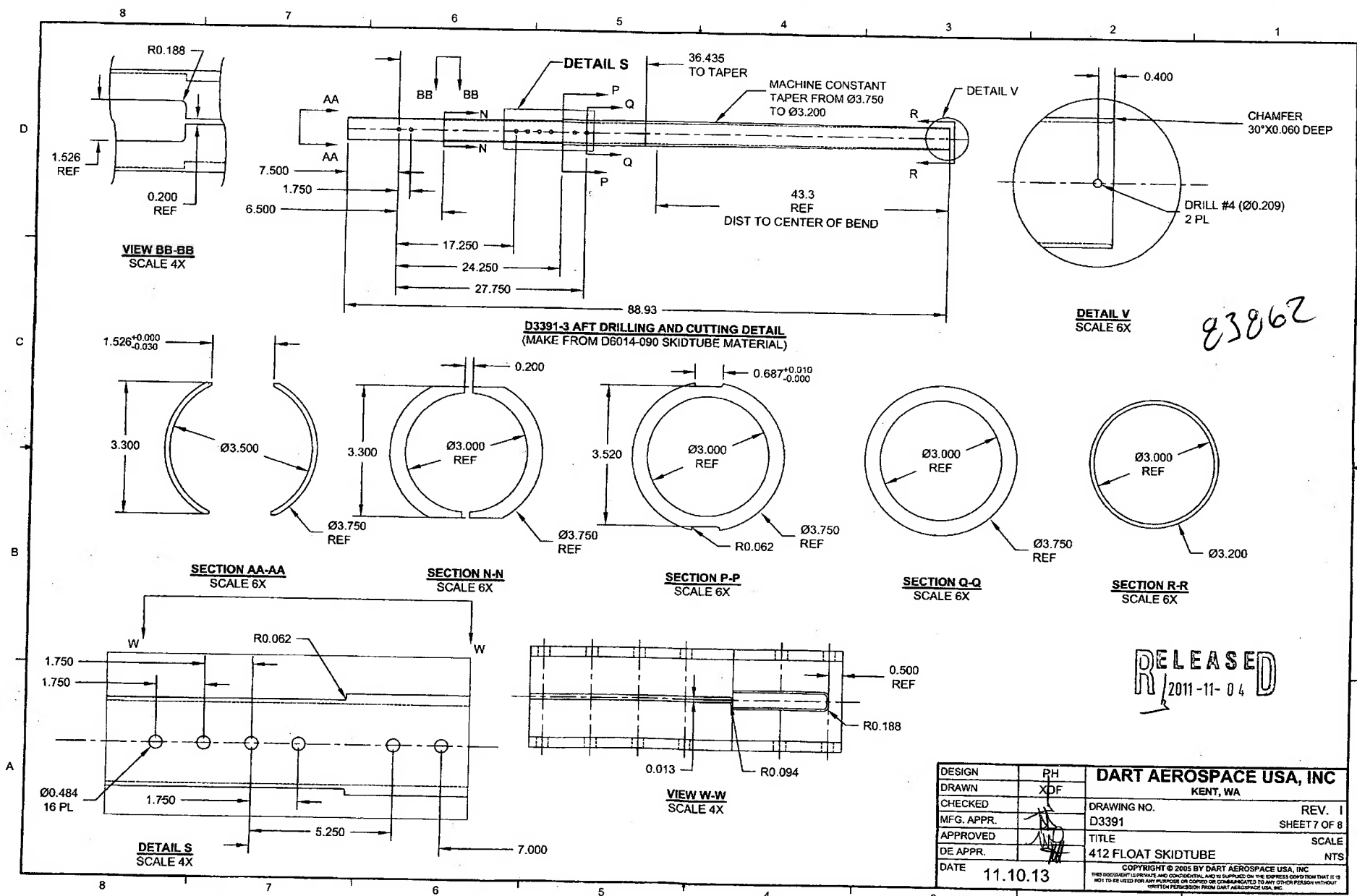
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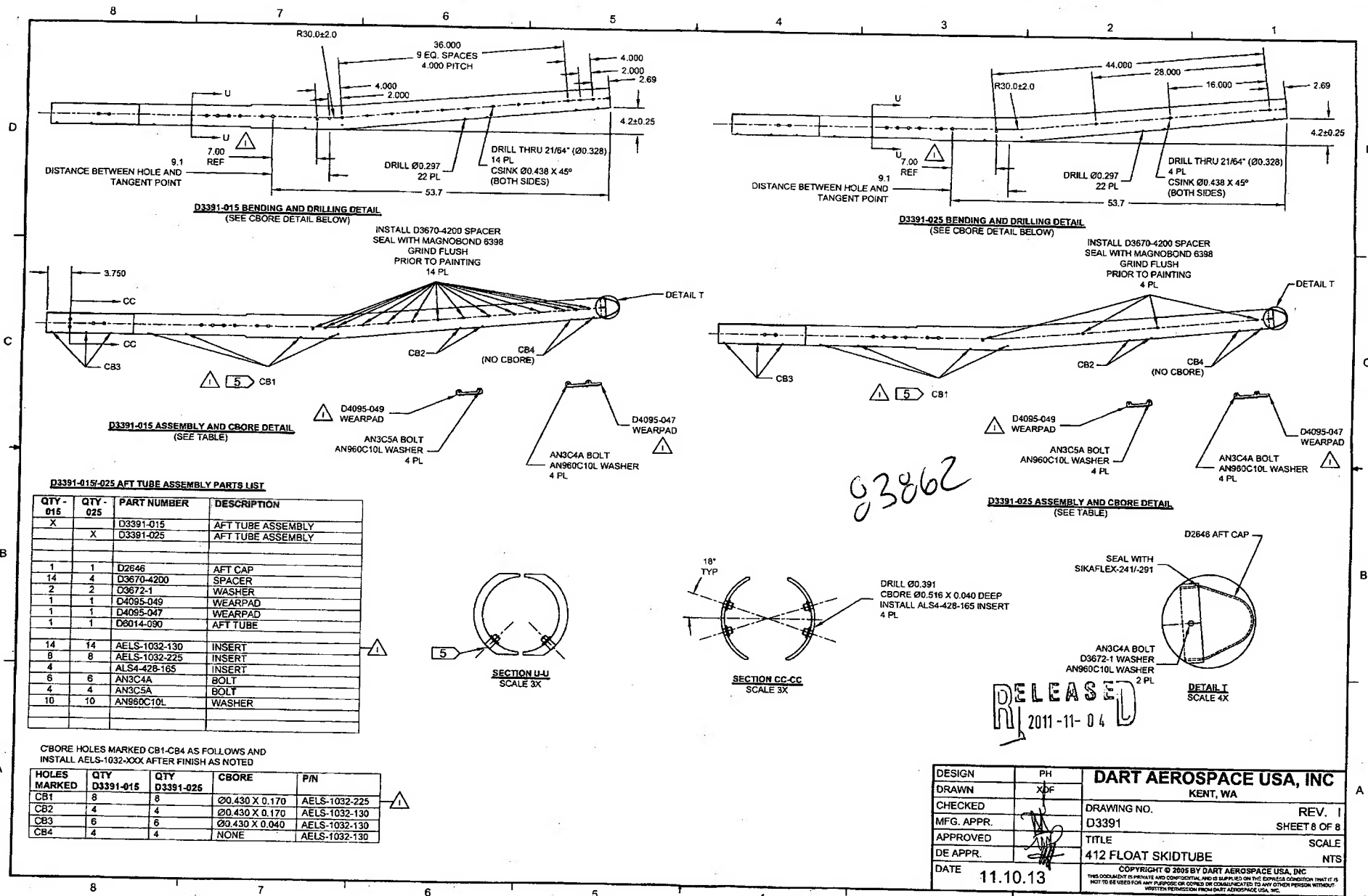
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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